Tuesday, 10/30/2007 2:50:26 PM Date: Kim Johnston **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : HINGE BRACKET Job Number : 35454 **Estimate Number** : 12543 : NIA : D35381 P.O. Number Part Number S.O. No. : JA D3538 REV.A This Issue : 10/30/2007 **Drawing Number** : 10254N/A Prsht Rev. : NC Project Number First Issue : MACHINED PARTS Type **Drawing Revision** : 33968 Previous Run . Material 20 Um: Each : 11/6/2007 **Due Date** Written By Checked & Approved By : Est Rev:A New Issue 06-10.03 EC Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 6061-T6 Bar 1.25 x 1.25" 1.0 M6061T6B1250X01250 Comment: Qty.: 0.1995 f(s)/Unit Total: 3.9900 f(s) 6061_T6 Bar 1.250" x 1.250 Batch:M BAND SAW BAND SAW 2.0 Comment: BAND SAW Cut blanks 1.500" long HAAS1 HAAS CNC VERTICAL MACHINING #1 3.0 Ò Comment: 1-Machine as per Folio FA651 and Dwg D3538 2-Deburn QC2 4.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK 5.0 Comment: SECOND CHECK HAND FINISHING RESOURCE #1* Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

Dart Aerospace Ltd

W/O:	/o: WORK ORDER CHANGES							
DATE	ATE STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>87/12/0</u> 7
	7		QA: N/C Closed:	Date:

		44.	UKN UK	DER NON-CONFORMANC	E (NCR)		•	
	Description of N	ıc		Corrective Action Section B			Approval	Approval
	Section A	•	Initial Chief Eng	Action Description Chief Eng	Sign & Date_	Section C	Chief Eng	QC Inspector
3.0	of collet caus,	ip out	ge)	Scapp and Destruy.	2/12/02			
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	STEP 3.0	Section A	Section A	Section A Initial Chief Eng 3.0 2 part Tools Stip out of collect causing margel on piece. R. C. operator error.	STEP Section A Section A Initial Chief Eng Chief Eng 3.0 2 part Tools Stip out of collet causing marge on piece R. C. operator error Initial Chief Eng SCRAP and Destrupt and Replace	STEP Description of NC Section A Initial Chief Eng Chi	STEP Description of NC Section A Initial Chief Eng Action Description Chief Eng Sign & Date 3.0 2 part Tools Stip out of collect causing marger Scape and Description Section C on picco. Constant and Replace Por 12.40	STEP Description of NC Section A Initial Chief Eng Action Description Chief Eng Chief Eng 3.0 I part Tools Slip out of collect causing many on piece. R. C. operator error. Initial Chief Eng Chief Eng Scap un Destrup OT/12/02 On piece. R. C. operator error.

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:50:26 PM User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HINGE BRACKET Job Number: 35454 Part Number: D35381 Job Number: Seq. #: Description: Machine Or Operation: 7.0 POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Form: rorocess

Page 2

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W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		, ; ;					
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
·			QA: N/C C	losed:	Date:

WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B			Annroval	val Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Corrective Action Section B Verification Section C Chief Eng Chief

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35454
Description: Hinge Bracket	Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Х	First Article		Prototype
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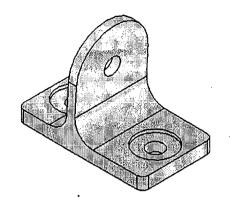
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0.375	+/-0.010	-375				
0.241	+/-0.010	.243				
0.830	+/-0.010	.829			-	
Ø0.172	+0.005/-0.001	.173				
Ø0.400	+0.006/-0.001	.399				
0.031	+/-0.010	. 03/				
1.31	+/-0.030	1.315	_	•		
0.375	+/-0.010	.37				
0.99	+/-0.030	.993				
0.125	+/-0.010	e125				
R0.19	+/-0.030	R. 190				
0.083	+/-0.010	.083				
93°	+/-0.5°	930				
0.674	+/-0.010	.677				
R0.38	+/-0.030	.380				
Ø0.172	+0.005/-0.001	172				
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Measured by:	SF	Audited by:	JL	Prototype Approval:	N/A
Date:	07/12/02	Date:	SOLVIE	Date:	N/A

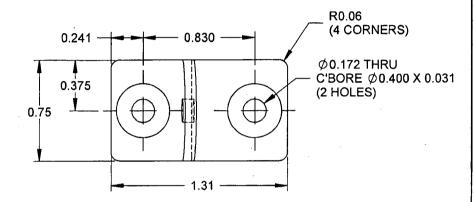
Rev	Date	Change	Revised by	Approved
Α	07.05:31	New Issue	KJ/JLM	Cidl
			771	7,0,7

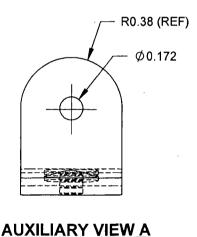


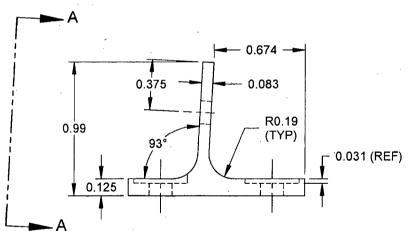
DESIG	N E	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHEC	KED	APPROVED	DRAWING NO.	REV. A
6	24	一册	D3538	SHEET 1 OF 2
DATE			TITLE	SCALE
	06.1	0.13	HINGE BRACKET	1:1
REV		DATE	DESCRIPTION	
Α		06.10.13	NEWISSUE	



RELEASED







D3538-1 HINGE BRACKET

SHOP COPY RETURN TO ENGINEERING

NOTES: 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B) NTROLLED COPY
2) FINISH: CHEMICAL CONVERSION COAT PER DART OSLOGICAL 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

SUBJECT TO AMENDMENT WITHOUT NOTICE

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) TOLERANCES ARE PER DART QSI 018 ÚNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

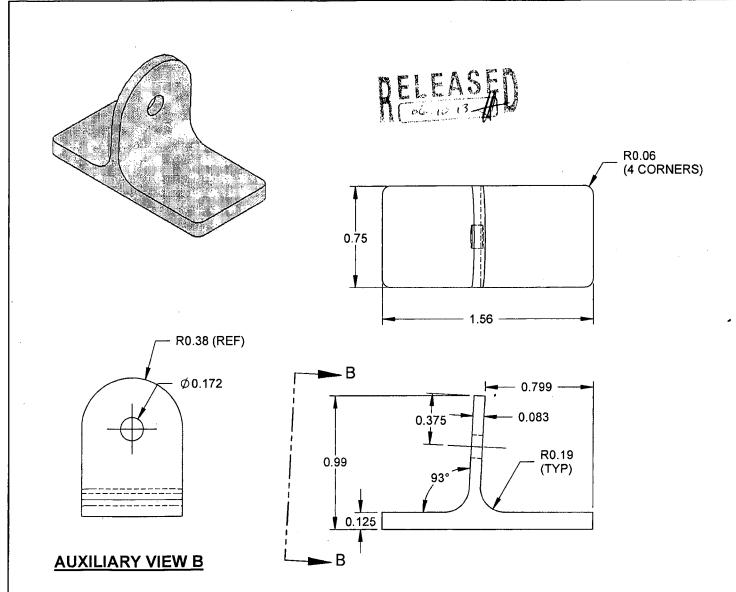
BREAK ALL SHARP CORNERS TO 0.010 MAX 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	D3538	REV. A SHEET 2 OF 2
06.10.13		HINGE BRACKET	SCALE 1:1



D3538-3 HINGE BRACKET

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B) NTROLLED COFY
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER IN INCLUSIONAL CONTROLLED COFY

WITHOUT NOTICE

WITHOUT NOTICE

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

SHOP COPY RETURN TO ENGINEERING

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